

Work Order ID 80989

80989

Page 1

March-06-12 9:17:23 AM

Item ID: D2661-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, LH Fwd Aft Out 206
 Start Date: 06/03/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 20/03/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/06 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2661	Rev E								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.

Program part number and batch number
 MACHINE AS PER DWG AND FOLIO FB073

FOLIO REV: AA
 DWG REV: E

PO
SL

12/05/20

12/05/23

20

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

PO
SL

12/05/20

12/05/23

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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 Revision ID: Stop *NS2*
 Item Name: Saddle, LH Fwd Aft Out 206
 Start Date: 06/03/2012 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 20/03/2012 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	SL	12-05-03		20	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	OK	12/05/23		20	0		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				20	16	12524	

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NOTE: Date & initial all entries

Picklist Print

March-06-12 9:17:27 AM

Page 1

Work Order ID: 80989

80989

Parent Item: D2661-1

D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 06/03/2012

Required Date: 20/03/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC

IPP REV:D

REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD

IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	47.0000	1	20			
D6101-003									**	PD		12/05/19	
Saddle Billet, 7075													

Location

Loc Qty

Loc Code

MAT040

28

73775

2

73780

7

78159

2

78599

10

MAT041

25

79587

25

MAT042

-7

MAT044

1

73769

1

→ 83310

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order: 80989	
Description: 206 Saddle, Outboard, Left side				Part Number: D2661-1	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.257	.257	.257	.257	.257
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.125	.126	.126	.126	.125
H	0.210	0.230		.220	.220	.220	.220	.219
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.323	1.323	1.323	1.323	1.324
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1325	1.136	1.134	1.132	1.130
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.124	.122	.125	.124	.120
Q	0.240	0.260		.251	.249	.250	.250	.244
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.126	.126	.127	.127	.122
T	1.565	1.585		1.571	1.574	1.575	1.571	1.569
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.912	0.932		.922	.922	.922	.922	.922
W	0.787	0.807		.798	.798	.798	.798	.798
X	5.990	6.010		6.001	6.001	6.001	6.001	6.001
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.499	.501	.497	.497
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.002	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.503	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.111	.111	.111	.111	.111
AI								

QL 8 mk 12/05/23

DART AEROSPACE LTD		Work Order:	80989
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 2 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

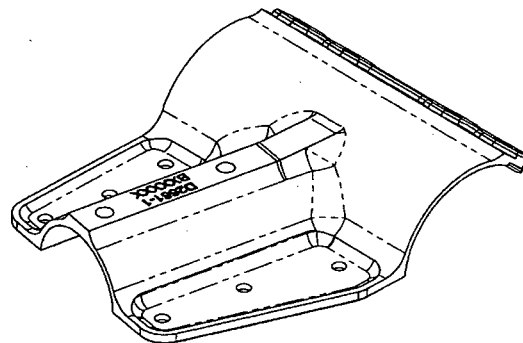
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
AJ								
AK								
AL								
AM								
AN								
Accept/Reject								

Measured by: DL **Date:** 12/05/20

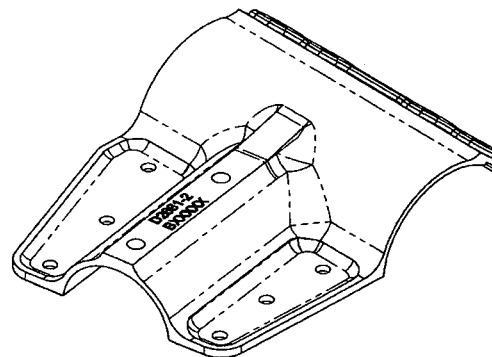
Audited by: CMK **Date:** 12/05/23

Prototype Approval: **Date:**

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	<u>[Signature]</u>



D2661-1 SADDLE, OUTSIDE, LH



D2661-2 SADDLE, OUTSIDE, RH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 80989 MLC
12/03/06

RELEASED
2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2,B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9085	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.31		

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. **D2661** REV. E
SHEET 1 OF 5

TITLE **SADDLE, OUTSIDE** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

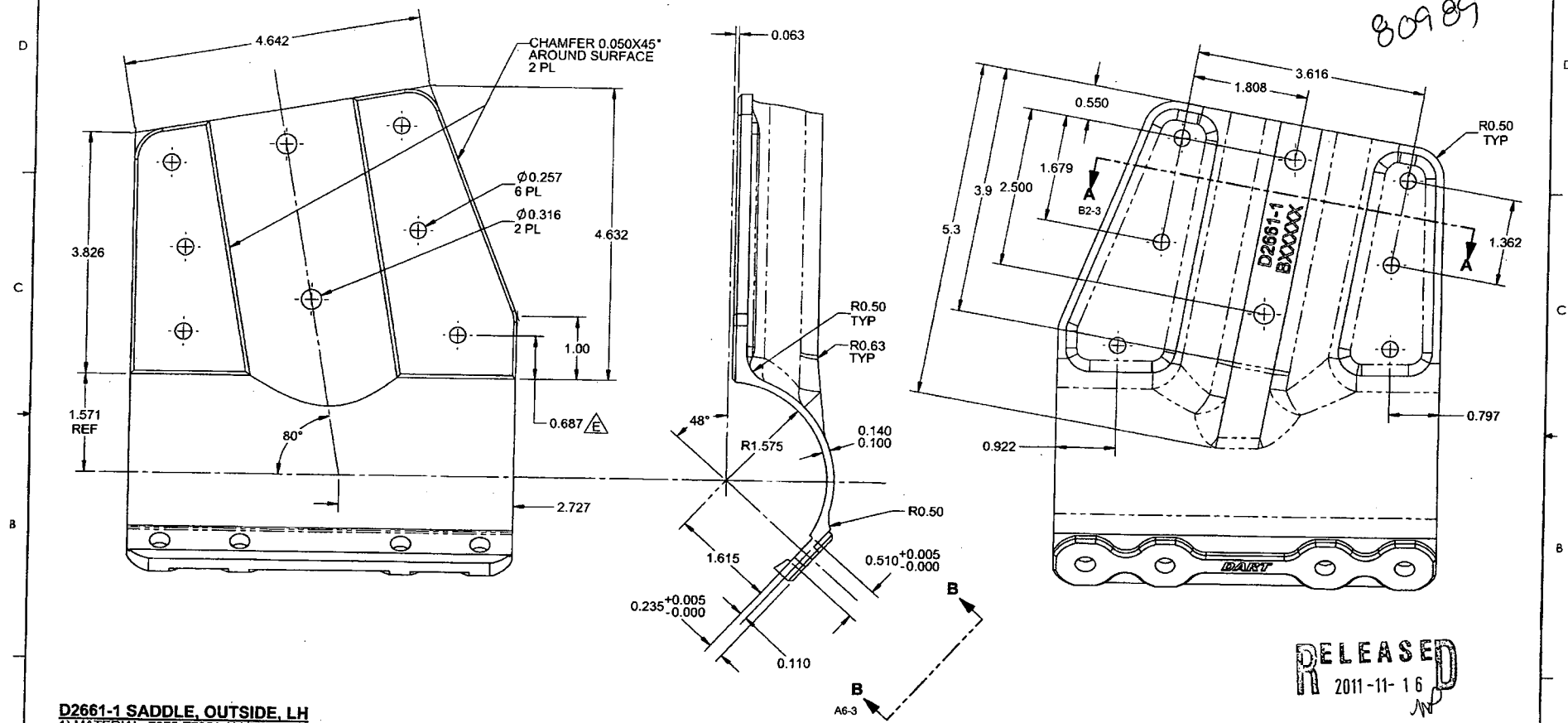
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80989



RELEASED
2011-11-16

D2661-1 SADDLE, OUTSIDE, LH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO. D2661	REV. E
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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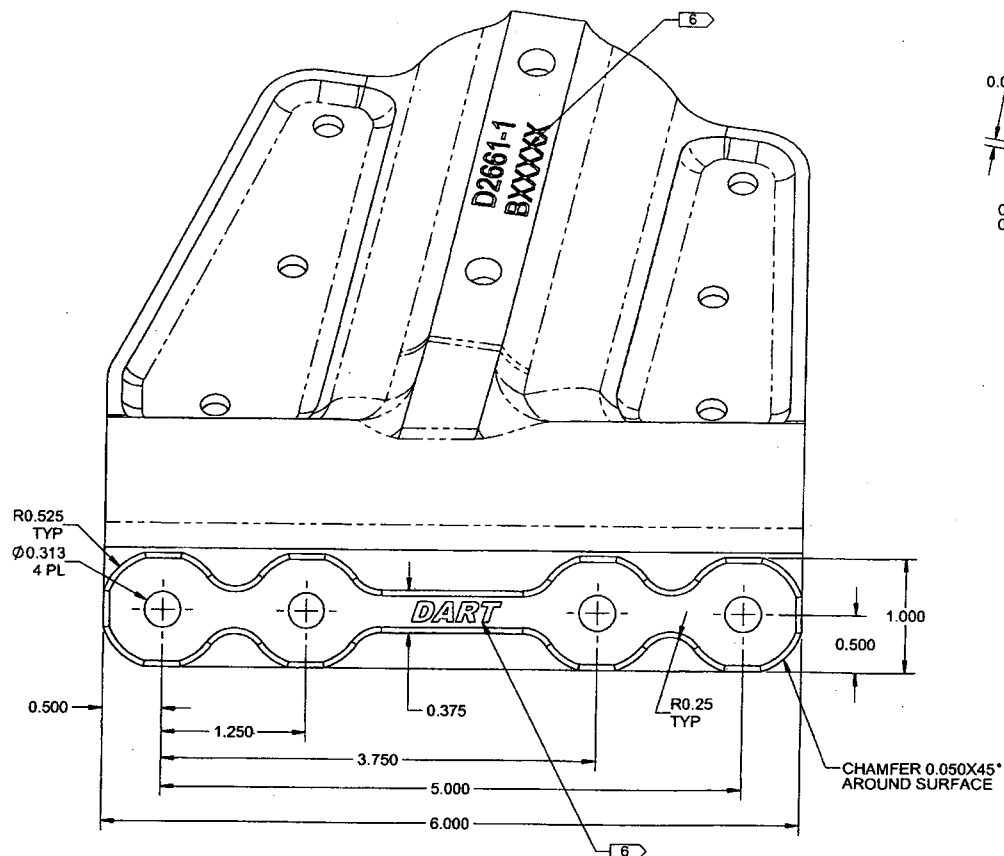
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

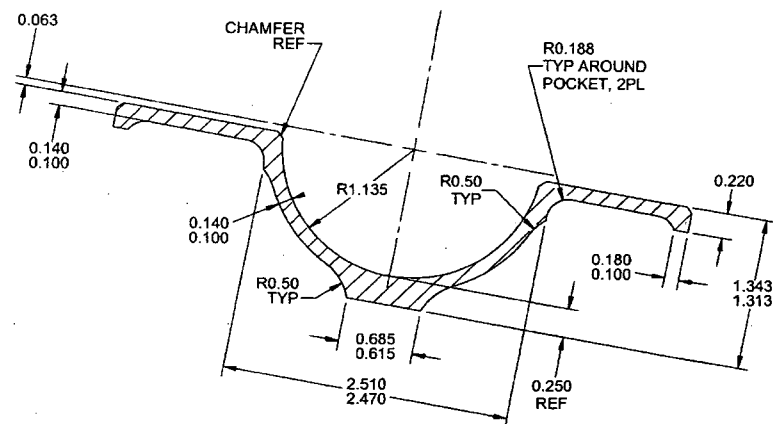
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8098



VIEW B-B
SCALE 1.5X A4-2
VIEW ROTATED



VIEW A-A
SCALE 1.5X C3-2

RELEASED
2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2661	REV. E
MFG. APPR.		TITLE	SHEET 3 OF 6
APPROVED		SADDLE, OUTSIDE	SCALE
DE APPR.			NTS
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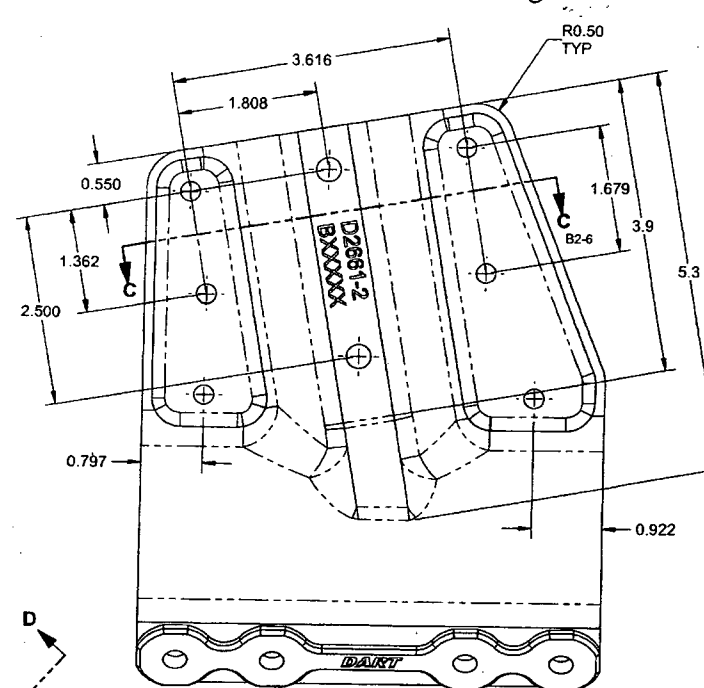
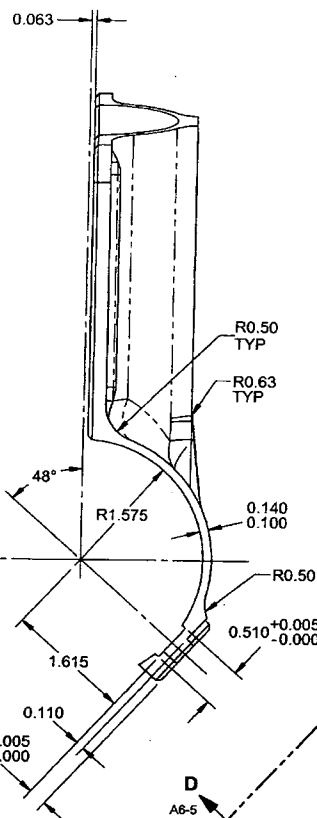
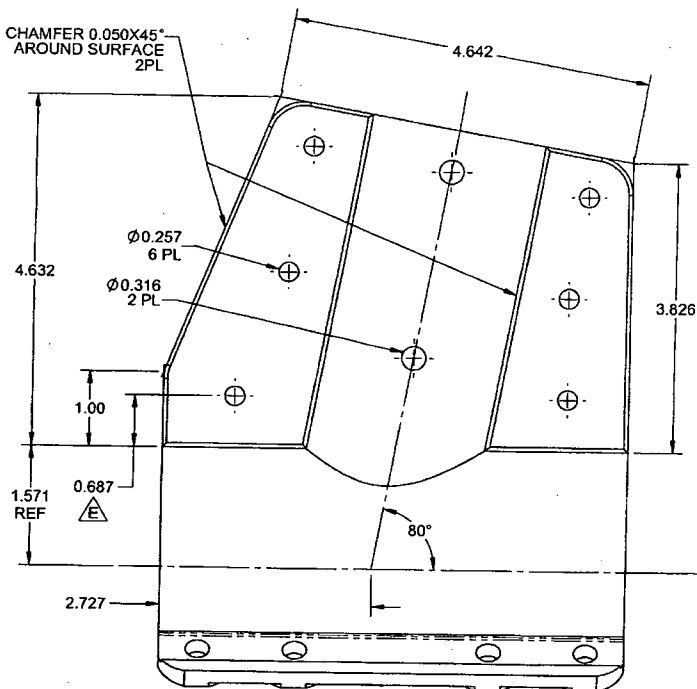
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NOTE: Date & initial all entries

CHAMFER 0.050X45°
AROUND SURFACE
2PL



D2661-2 SADDLE, OUTSIDE, RH

- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

RELEASED
2011-11-16

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DRAWN		KENT, WA	
CHECKED	ASS	DRAWING NO. D2661	REV. E
MFG. APPR.		TITLE SADDLE, OUTSIDE	SHEET 4 OF 5
APPROVED		SCALE	NTS
DE APPR.		DATE 11.10.31	

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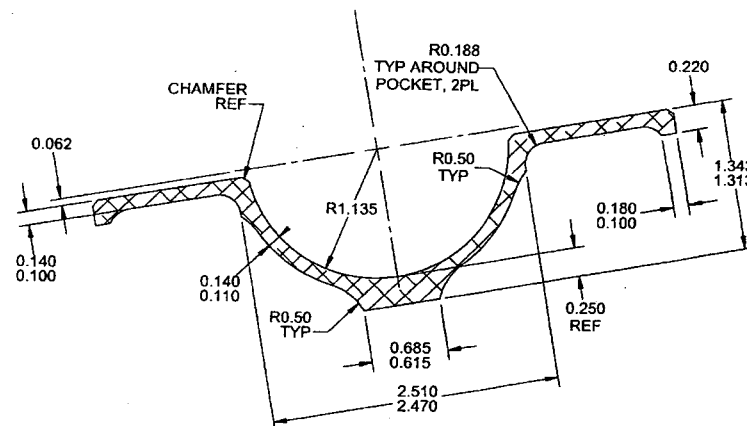
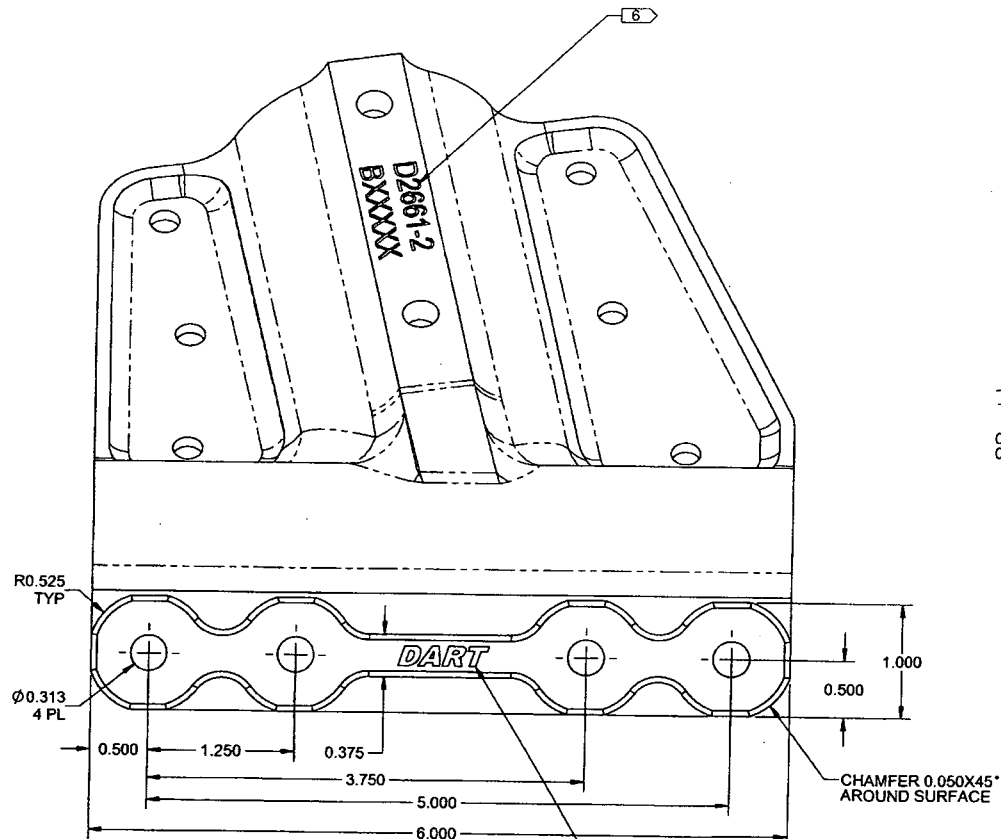
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Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 2	

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B	0.256	0.263		.257	.257	.257	.257	.257
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.126	.126	.125	.125	.123
H	0.210	0.230		.219	.219	.217	.218	.218
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.323	1.323	1.323	1.323	1.322
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.137	1.137	1.134	1.134	1.134
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.120	.120	.120	.120	.120
Q	0.240	0.260		.244	.244	.246	.245	.246
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.121	.122	.122	.120	.121
T	1.565	1.585		1.575	1.577	1.572	1.574	1.574
U	0.540	0.560		.550	.551	.551	.550	.550
V	0.912	0.932		.922	.922	.922	.922	.922
W	0.787	0.807		.798	.798	.798	.798	.798
X	5.990	6.010		6.001	6.001	6.001	6.001	6.001
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.501	.500	.500	.497	.499
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
AI								

QC2 = JL 12/05/22

QC8 = AN 12/05/23

DART AEROSPACE LTD		Work Order:	80989
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		-.257	-.257	-.257	-.257	-.257
C	0.315	0.322		-.316	-.316	-.316	-.316	-.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		-.123	-.123	-.125	-.126	-.124
H	0.210	0.230		-.218	-.220	-.220	-.221	-.220
I	0.615	0.685		-.680	-.680	-.680	-.680	-.680
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.322	1.323	1.323	1.323	1.323
L	0.178	0.198		-.188	-.188	-.188	-.188	-.188
M	0.470	0.530		-.500	-.500	-.500	-.500	-.500
N	1.125	1.145		1.134	1.132	1.133	1.138	1.134
O	0.100	0.180		-.140	-.140	-.140	-.140	-.140
P	0.100	0.140		-.122	-.121	-.121	-.122	-.123
Q	0.240	0.260		-.246	-.250	-.249	-.247	-.248
R	0.677	0.697		-.687	-.687	-.687	-.687	-.687
S	0.100	0.140		-.122	-.122	-.121	-.122	-.124
T	1.565	1.585		1.574	1.573	1.574	1.579	1.575
U	0.540	0.560		-.550	-.550	-.550	-.550	-.550
V	0.912	0.932		-.922	-.922	-.922	-.922	-.922
W	0.787	0.807		-.798	-.798	-.798	-.798	-.798
X	5.990	6.010		6.001	6.001	6.001	6.001	6.001
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		-.498	-.501	-.501	-.501	-.500
AA	0.312	0.319		-.314	-.314	-.314	-.314	-.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		-.500	-.500	-.500	-.500	-.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		-.237	-.237	-.237	-.237	-.237
AG	0.510	0.515		-.512	-.512	-.512	-.512	-.512
AH	0.100	0.120		-.112	-.112	-.112	-.112	-.112
AI								

QC2 = JK 12/05/23

QC8 = MK 12/05/23

DART AEROSPACE LTD		Work Order:	80989
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 2	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	17	18	19	20
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.257	.257	.257	.257	.257
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.123	.125	.124	.124	.124
H	0.210	0.230		.220	.220	.220	.220	.218
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.323	1.324	1.323	1.324	1.323
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.133	1.134	1.134	1.134	1.134
O	0.100	0.180		.140	.140	.140	.140	.140
P	0.100	0.140		.120	.121	.121	.120	.121
Q	0.240	0.260		.249	.248	.248	.249	.249
R	0.677	0.697		.687	.687	.687	.687	.687
S	0.100	0.140		.122	.120	.121	.122	.122
T	1.565	1.585		1.573	1.574	1.574	1.574	1.574
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.912	0.932		.922	.922	.922	.922	.922
W	0.787	0.807		.798	.798	.798	.798	.798
X	5.990	6.010		6.001	6.001	6.001	6.001	6.001
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.499	.500	.502	.502
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.500	.500	.500	.500	.500
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
AI								

QC2 = SL 12/05/23

QC8 = ML 12/05/23

